

Date: Monday, 11/19/2007 4:04:43 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP WELDMENT
Job Number : 35861-2	
Estimate Number : 10779	
P.O. Number :	Part Number : D3463041
This Issue : 11/19/2007 S.O. No. :	Drawing Number : D3463 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 34844	Material :
Written By :	Due Date : 12/8/2007 Qty: 4 Um: EACH
Checked & Approved By : <i>[Signature]</i>	
Comment : EST REV. A 05.11.18 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	238806	SS DOWEL PIN 1" LONG
-----	--------	----------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	238-806	SS DOWEL PIN 1" LONG	11105037 → 8x

2.0	D34533	Clevis
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3453-3	Clevis	B35879 → 4x
			B35880 → 4x
			B35880 → 4x

3.0	D34637	Drag Arm
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-7	Drag Arm	B35882 → 4

4.0	D34631	Arm
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-1	Arm	B35881 → 4x

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 35861

Part Number: D3463041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D34633

Step



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description
1 D3463-3 Step

Batch

B34120-2

→ 4x

ly

6.0

D34635

End Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description
2 D3463-5F Step Flat Pattern

Batch

B33808

→ 8x

ly

7.0

D34535

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description
1 D3453-5 Plug

Batch

B35879

→ 4x

B35880

→ 4x

ly 08/04/09

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3463 using DT8875

ly 08/04/22

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-04-22

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/22 (74)

PD 08-04-22

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Mask areas indicated on dwg D3463 (holes, threads)

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

m 107550

BR 08-04-

30 min.

22/04/2008

S.088 12.50

#1 404.6 F

B.35861 F

#3 F

#0.3463041 F

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 35861

Part Number: D3463041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M106894



(4X)

Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3463 and QSI 005 4.4

m-f

08/04/22

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



yl



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-04-23

(XU)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



(4X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8/4/23

SP

15.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/24

Comment: FINAL INSPECTION/W/O RELEASE

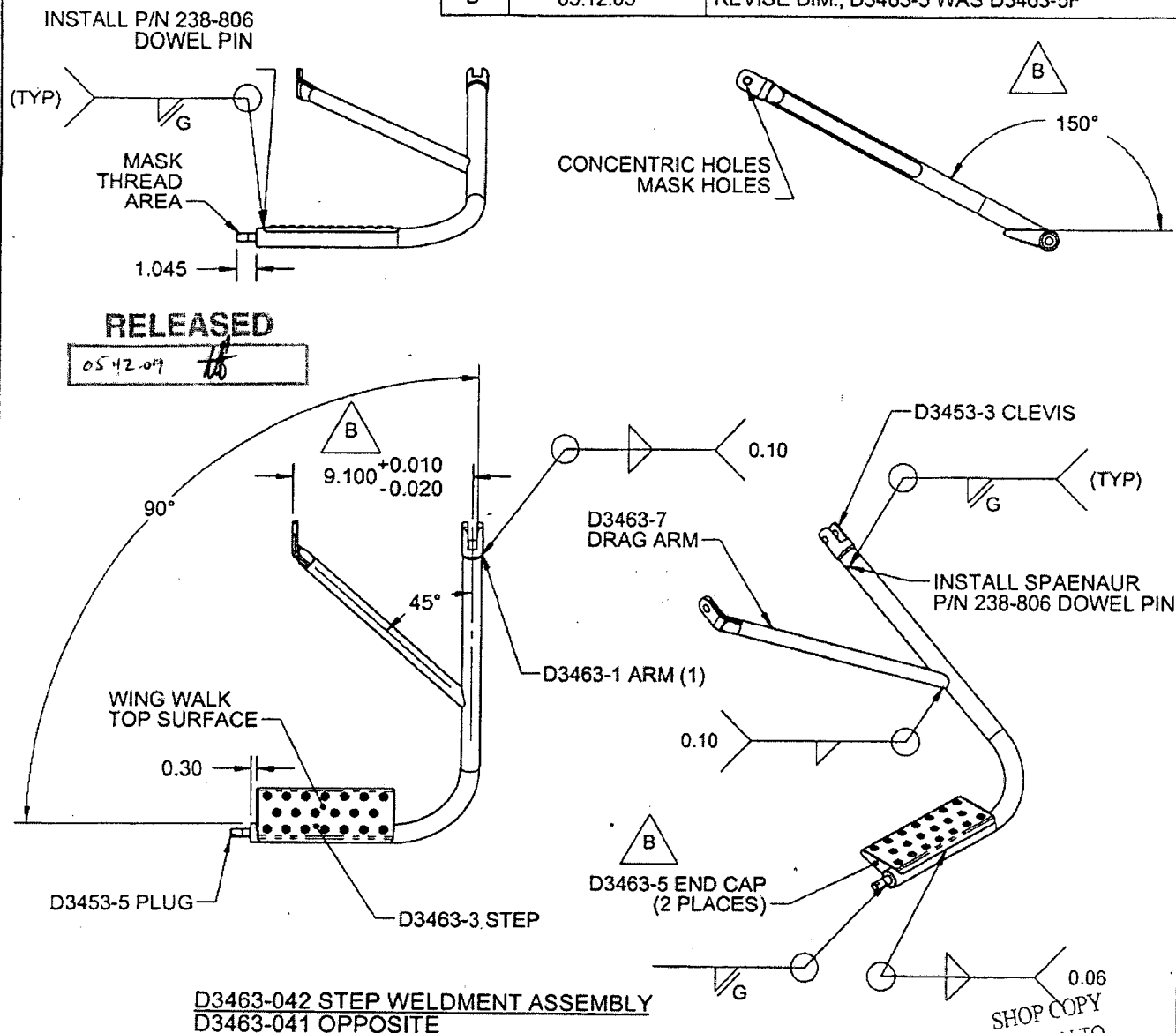
Job Completion



mf 08-04-23



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	



NOTES:

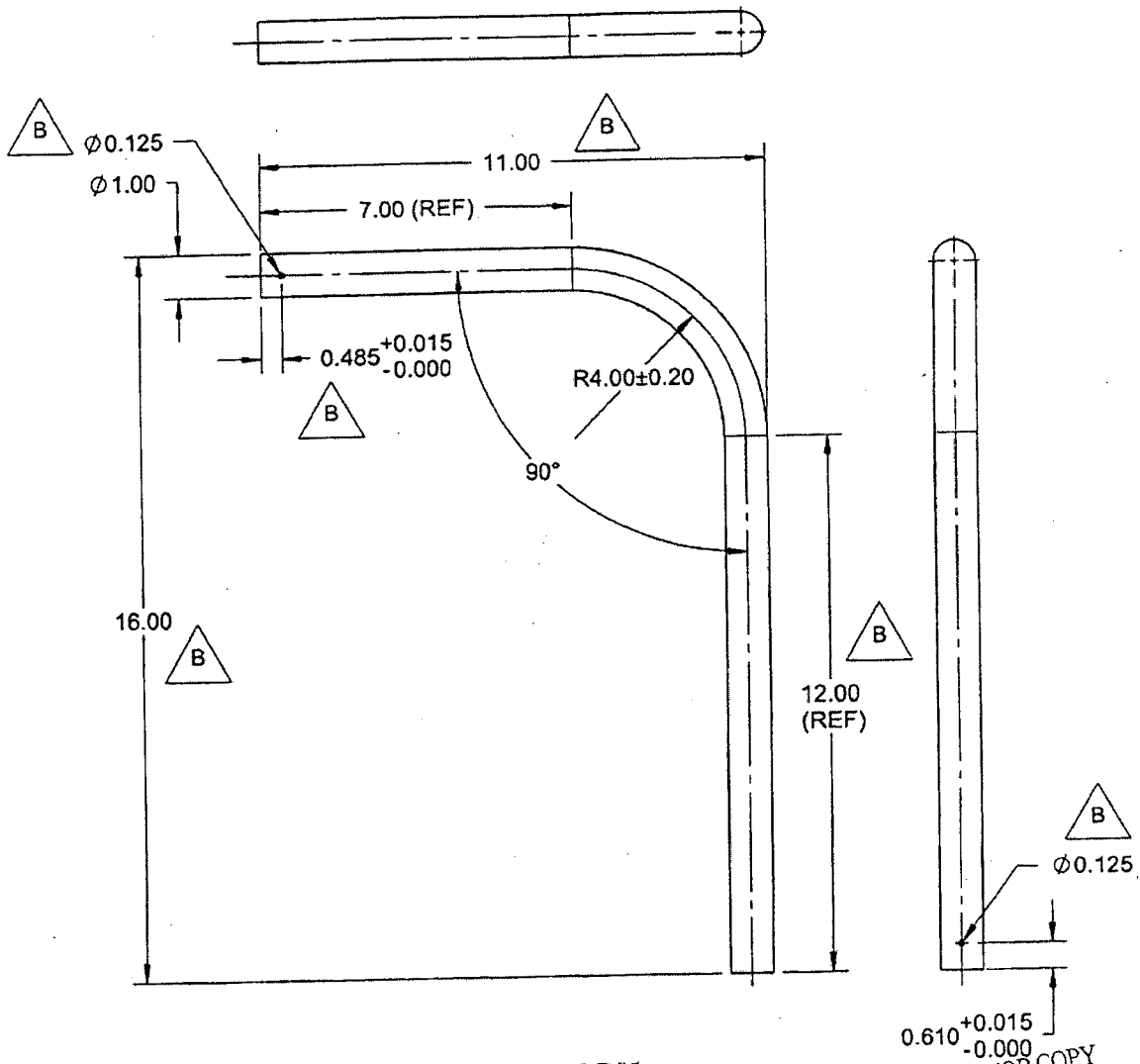
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED05.12.09 *[Signature]***D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W 120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

0.610^{+0.015}
-0.000
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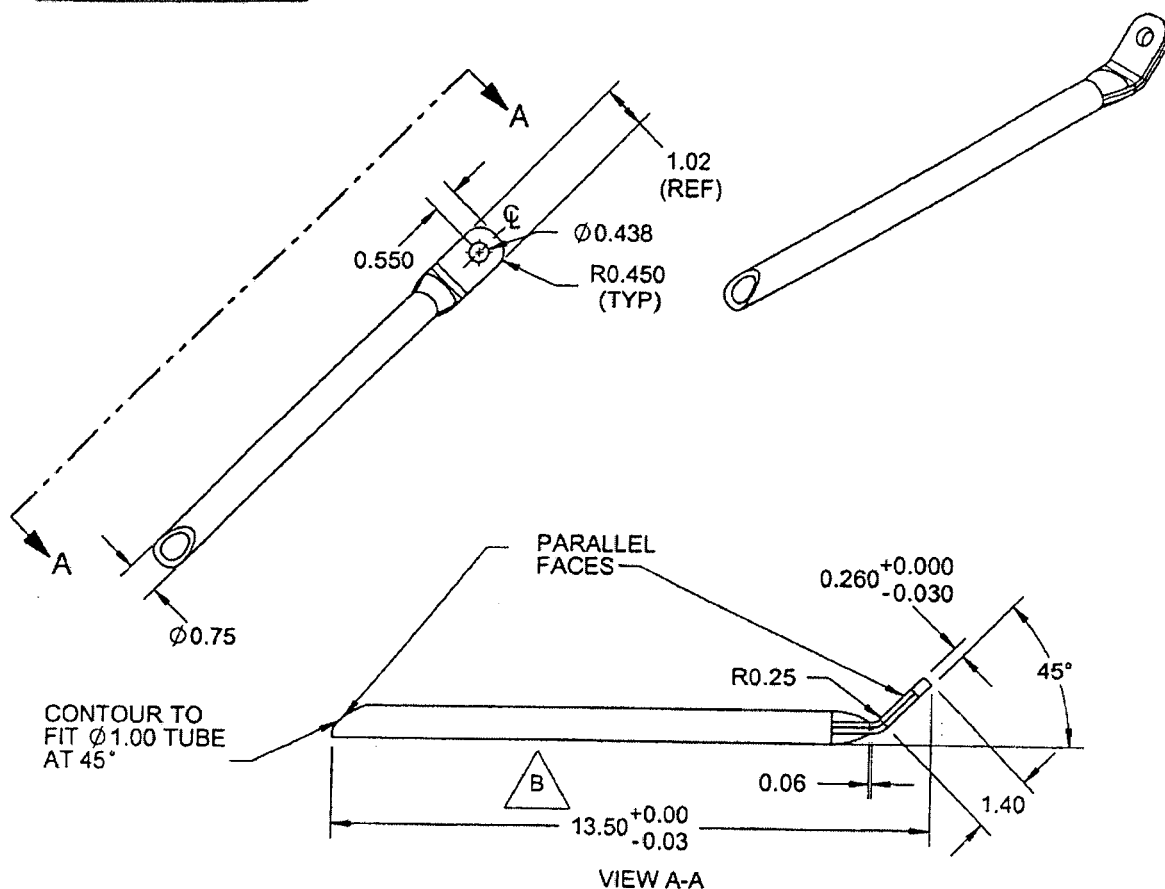
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CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.05 #



D3463-7 DRAG ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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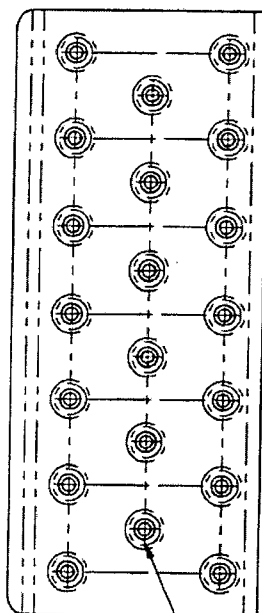
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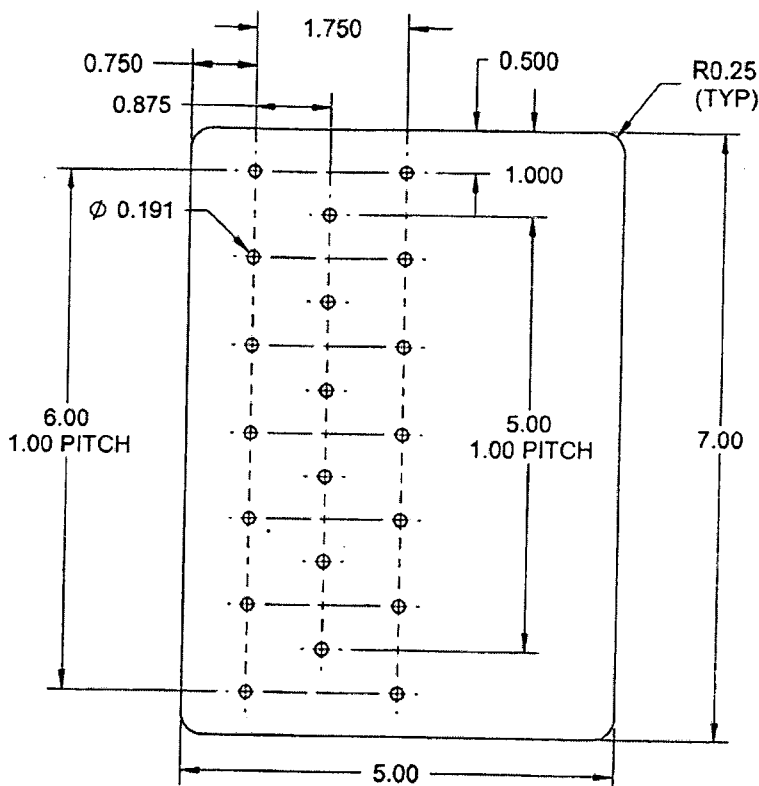
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED

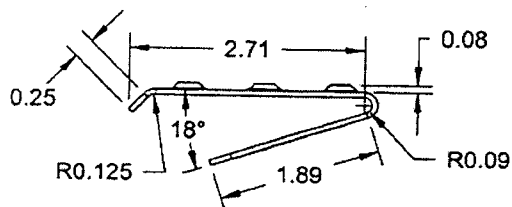
05.12.05 #



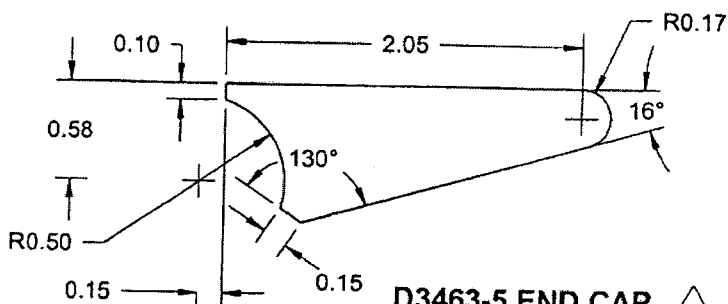
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP

SCALE 1:1

SHOP COPY B

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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